

Date: Wednesday, 6/6/2007 3:04:17 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	CONSOLE SIDE LH (206 HI-SLOPE)
Job Number	32819			
Estimate Number	11000			
P.O. Number	N/A		Part Number	D26021
This Issue	6/6/2007	S.O. No. N/A	Drawing Number	D2602 REV A1
Prsht Rev.	NC		Project Number	N/A
First Issue		Type	Drawing Revision	A1
Previous Run	31332		Material	N/A
Written By			Due Date	6/30/2007
Checked & Approved By	Qty: 6 Um: Each			
Comment	Est. D 04.02.25 Rerformat KJ/RF Note: Issue with part number D2602-2 Est Rev:E Now On Waterjet 07-03-22 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M2024T3S040	2024-T3 .040 sheet  Comment: Qty.: 1.4146 sf(s)/Unit Total: 8.4874 sf(s) 2024-T3 .040 sheet Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <u>M103539L6</u> <u>M100347 (2)</u> SAD 07/06/15
2.0	WATER JET	FLOW WATER JET  Comment: FLOW WATER JET 1-Cut as per Dwg D2602 *****Same Cutting File for -1 & -2 ***** Dwg Rev: <u>A1</u> (PJO) Prog Rev: <u>A1</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAD 07/06/15 (6)
4.0	QC8	SECOND CHECK  Comment: SECOND CHECK SAD 07/06/15 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2602-1 PAR #: N/A Fault Category: Part / fab. assy ^{med & small} NCR: Yes No DQA: PA Date: 07.08.24
 QA: N/C Closed: PA Date: 07.08.24

NCR: <u>32819</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07/06/15</u>	<u>2.0</u>	<u>Scrap wrong material B# <u>100742</u> M60615040</u>	<u>Scrap, destroy, replace</u>	<u>Scrap, destroy, replace</u>	<u>SAD</u>			
			<u>Scrap</u>	<u>Verify the material prior to using.</u>	<u>07/06/15</u>	<u>EV</u>	<u>07/06/15</u>	<u>08/04/22</u>

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 32819

Part Number: D26021

Job Number:



Seq. #: Machine Or Operation:

Description:

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2602

SB 07/08/19

6

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/08/2016

6x

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M/L

07/08/22

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/08/22

6

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/08/23C

6

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/24

6

Job Completion



07/08/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32819
Description: Console Side LH/RH	Part Number:	D2602-1/-2
Inspection Dwg: D2602 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	SAB	Audited by:	CF	Prototype Approval:	N/A
Date:	07/06/15	Date:	07/06/18	Date:	

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	TT

RELEASED
97.11.04 KE
TSR A421

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
<i>KE</i>	BW	VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	REV. A
<i>KE</i>	<i>J</i>	
DATE	DRAWING NO.	SHEET 1 OF 1
97.10.22	D2602	1
TITLE		SCALE
A1	97.10.22 D2602 WAS D206-547-21/-22	1:4
	ADD FINISH	

